SHIP MONDAY

Work Orde			_				,		,		Page
Item ID: Revision ID:	D3942-3			Accept					Setup S	* *************************************	
	Clip 5/13/2010 5/14/2010	Start Qty: 20.00 Req'd Qty: 20.00			Cust Item I Customer:	D:	·		S	top	
Approvals:	Process Pla	an: MF	•	5-/3Tooling: SPC (Y/N):		ite:				tart	
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accep Qty	t Reject Qty	Reject Numbe	
Draw Nbr	Rev	ision Nbr							~~~		· ·
D3942	Rev	Α,									•
100				0.00							

FLOW CNC Waterjet

Waterjet

Memo

1-Cut as per Dwg D3942-1 Dwg Rev: Prog Rev:

2-Deburr if necessary

Debur =7 m. 1 w/05/14



110

QC2- Inspect parts off machine FAI/FAIB

0.00

0.00

Memo

0.00

B10-5-13

B 10-5-13

Quality Control

Dart Aerospace Li

W/O: WORK ORDER CHANGES										.,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,
DATE	STEP	PRO	CEDURE CHA	NGE		Ву	Date	Qу	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No			PAR #: Fault Category:							
	R								Date: _	
NCR:	T 113	V	VORK ORD	ER NON-CONFO	DRMANCE	(NCR)	1			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Action Descri Chief Eng		Sign & Date	Verifica Section		Approval Chief Eng	Approval QC Inspector
									1	
									·	
NOTE D		*					t .	ı	1	l

H:\fFGRMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 58653

Thursday, May 13, 2010 8:34:12 AM



Page 2

Item ID:

D3942-3

Accept

Setup Start

Stop



Revision ID:

Item Name:

Start Date:

Clip

Required Date: 5/14/2010

5/13/2010

Start Qty: 20.00

Req'd Qty: 20.00

Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Date: _____

Tooling:

Date:

Run Start



Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ **Work Center ID**

120

Quality Control

Operation Description

QC8- Inspect parts - second check

Memo

Set Up/ **Run Hours**

8 000 24

Draw Draw Number Rev.

Plan Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

140

Packaging

Packaging

Identify as per dwg & Stock Location:

Memo



0.00

0.00

150



Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/05/17 A) BS 10-5-17 36

Dart Aerospace Ltd W/O: WORK ORDER CHANGES DATE STEP PROCEDURE CHANGE By Date Qy Approval Chief Eng / Prod Mgr

Part No	:	PAR #:	Fault Categ	ory:	NCR: Yes	No DQA:	Date:	
	Res	solution:	Disposition		QA: N/C C	losed:	Date:	
NCR:			WORK ORDE	R NON-CONFO	RMANCE (NC	R)		
	Description of NC		Corrective Action	Section B	Varitions			
DATE	STEP	Section A	Initial Chief Eng	Action Descrip Chief Eng	tion Sign Date	3 SECTION 1	Approval Chief Eng	Approva QC Inspecto

Approval QC Inspector

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Picklist Print

Thursday, May 13, 2010 8:34:11 AM

Work Order ID: 58653

Parent Item:

Comments:

D3942-3

Parent Item Name: Clip



Start Date: 5/13/2010

Required Date: 5/14/2010

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M304S18GA		Purchased	No			100	sf	141.1179	0.015	,6		

304/316 .050 Sheet

Location	Loc Oty	Loc Code
MAT20	141.1179	
108156	1.7	
111743	10.1	
112885	33.3179	
113062	٠ 96	

788C11

1210-5-13

Dart Ao	rospace	l td								
W/O:	ospace	Ltu	W	ORK ORDER CHANG	GES	· .		-		
DATE	STEP	PR	OCEDURE CHA	***************************************		By Date (Approval Chief Eng / Prod Mgr	Approva QC Inspector
		-							•	
Part No	•	PAR #:	Fault Cate	gory:	_ NCR	: Yes	No DQA	: <u> </u>	Date:	
		solution:							Date:	
NCR:			WORK ORD	ER NON-CONFORM	ANCE	(NCF	R)			
DATE	STEP	Description of NC		Corrective Action Sect	ion B		Verific	ation	Approval	Approval
	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign 8 Date	Section		Chief Eng	QC Inspector
						·			To the first war when	

DART AEROSPACE LTD	Work Order:	58653
Description: Clip	Part Number:	D3942-3
Inspection Dwg: D3942 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
-----------------	-----------

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.00	+/-0.030	2.006	*			
0.75	+/-0.030	.756	×			
Ø0.257	+0.006/-0.001	7759	8			
Ø0.129	+0.005/-0.001	1139	৮			·
0.31	+/-0.030	P0E,	>			
0.38	+/-0.030	1380	6			
0.25	+/-0.030	676.	<i>ن</i> ې	<u>.</u>		
0.25	+/-0.030	076.	ס			
0.25	+/-0.030	, 357	4			
0.75	+/-0.030	,754	A			
					,	

Measured by:	B	Audited by:	7	Prototype Approval:	N/A
Date:	10-2-13	Date:	10/15/14	Date:	N/A

Rev	Date	Change	Revi	sed l	χу	Approved
Α	09.06.22	New Issue	KJ	_\$	}- _	

Dart Ae	rospace	e Ltd								•	
W/O:				W	ORK ORDER CHA	ANGES					
DATE STEP			PROCEDURE CHANGE				Ву	Date Q	Approval Chief Eng / Prod Mgr	Approva QC Inspecto	
						9					
				•							
Part No	:		PAR #·	Fault Cate		NC	P: Voc	No DOA:	Data		
_				Fault Category: NCR: Yes No Disposition: QA: N/C Closed							
NOD		esolution.			ER NON-CONFO				Date: _		
NCR:	T		,			-,-	(IVCh	1)			
DATE	STEP	Þe	escription of NC Section A	Initial Chief Eng	Corrective Action Action Description	Section B	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspecto	
i											
:			•								
NOTE: D	1 ate & initia	al all entries									

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

0 D 1166 -.166 0.25 0.25 0.75 686 С Ø0.129 2 PL 2.00 Ø0.257 -17/2 R0.13 TYP - 0.38 ---0.050 REF 25 D3942-3 CLIP

D

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR AMS 5524
18 GAUGE (0.050 THICK)
REF DART SPEC M304S18GA
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3942-3" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.02 lbs

DESIGN	45	DART AEROSPACE LTD					
DRAWN	1	HAWKESBURY, ONTARIO, CANADA					
CHECKED	PH	DRAWING NO.	REV. A				
MFG. APPR.	8	D3942	SHEET 2 OF 2				
APPROVED	140	TITLE	SCALE				
DE APPR.	#	BRACKET	NTS				
DATE 09.0	5.06	THIS DOCUMENT BY MINISTER OF 2009 BY DART AEROSPACE LTD THIS DOCUMENT BY MINISTER OF CONTRIBUTION, AND IS SUPPLY ON THE EXPRESS CONCIDENT THAT IT IS BOT TO BE USED FOR ANY PARIPOSE OF COPPED OF COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN FERMINERON FROM DART ANDOPINE LTD.					

Dart Aerospace	Ltd:
----------------	------

W/O:			WC	RK ORDER CHANG	ES						
DATE	STEP	PRO	PROCEDURE CHANGE			Date	Qy	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No		PAR #:	Fault Cate	gory:	NCR: Yes	No DQA	:	Date:			
	R	esolution:	Disposition:								
NCR:			WORK ORD	ER NON-CONFORMA	ANCE (NC	R)					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Description Chief Eng	on B Sign Date		at on	Approval Chief Eng	Approval QC Inspector		
		→									

^{◆ *} H:\fPORMS\Quality Assurance\approved QA\NCRWO RevE